

Date: Tuesday, 27/03/2007 7:38:41 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 31301		Part Number	: D32941	
Estimate Number	: 11181		Drawing Number	: D3294 REV A1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 27/03/2007 S.O. No. : N/A		Drawing Revision	: A1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 03/04/2007 Qty: 10 Um: Each	
Previous Run	: 31301				
Written By					
Checked & Approved By					
Comment	: Est A 04.08.24 New issue KJ/JLM Est Rev:B Now On Waterjet 07-03-26 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S080	2024-T3 .080 sheet  <b>Comment:</b> Qty.: 2.1072 sf(s)/Unit Total : 21.0725 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3294-1 Batch: m102838 <i>m1 07 03 28</i> (10)
2.0	WATER JET	FLOW WATER JET  <b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3294 Dwg Rev: A1 <i>m1 07 03 29</i> (10) Prog Rev: A1
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  <i>m1 07 03 29</i> (10) <b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK  <b>Comment:</b> SECOND CHECK <i>11 07 04 02</i> (8)

Date: Tuesday, 27/03/2007 7:38:41 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31301

Part Number: D32941

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SAD 07/04/12 (8)

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3294

SB 07/04/11 8

7.0 QC5 INSPECT WORK TO CURRENT STEP



Lot 04-11

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-04-12 (8)

9.0 POWDER COATING POWDER COATING



M102361

(8X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1 07/04/12

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



10-04-13 (8)

Comment: INSPECT CHEMICAL CONVERSION COAT

11.0 PACKAGING 1 PACKAGING RESOURCE #1



10-04-13 (8)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10-04-13 (8)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



10-04-13 (8)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



10-04-13

Date: Monday, 3/19/2007 4:38:14 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BRACKET	
Job Number	31301		Part Number	D32941	
Estimate Number	11181		Drawing Number	D3294 REV A1	
P.O. Number			Project Number	N/A	
This Issue	3/19/2007	S.O. No.	Drawing Revision	A1	
Prsht Rev.	NC		Material		
First Issue	/ /	Type	MACHINED PARTS	Due Date	3/30/2007
Previous Run			Qty:	10	
Written By			Um:	Each	
Checked & Approved By	<u>07.03.20</u>				
Comment	Est A 04.08.24 New issue KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S080	2024-T3 .080 sheet
2.0	SHEAR	<p>Comment: Qty.: 2.1072 sf(s)/Unit Total : 21.0725 sf(s)            Material: 2024-T3 (QQ-A-250/4) 0.080" thick            (M2024T3S.080)            Identify for D3294-1            Batch: _____</p>
3.0	HAAS <i>water jet</i>	<p>Comment: SHEAR            Cut blank: 1.950" x 0.700" grain along 1.950"            Note: To be made in multiples of 10</p>
4.0	QC2	<p>Comment: HAAS CNC VERTICAL MACHINING #1            Machine as per Folio FA445 and Dwg D3294            Stack of 10            Identify as D3294-1</p>
5.0	QC8	<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>
		<p>Comment: SECOND CHECK</p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31301

Part Number: D32941

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

7.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3294

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

13.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31301
Description: Bracket	Part Number:	D3294-1
Inspection Dwg: D3294	Rev: A1	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<u>M. M.</u>	Audited by:		Prototype Approval:	N/A
Date:	<u>07 03 29</u>	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	<i>[Signature]</i>
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	<i>[Signature]</i>



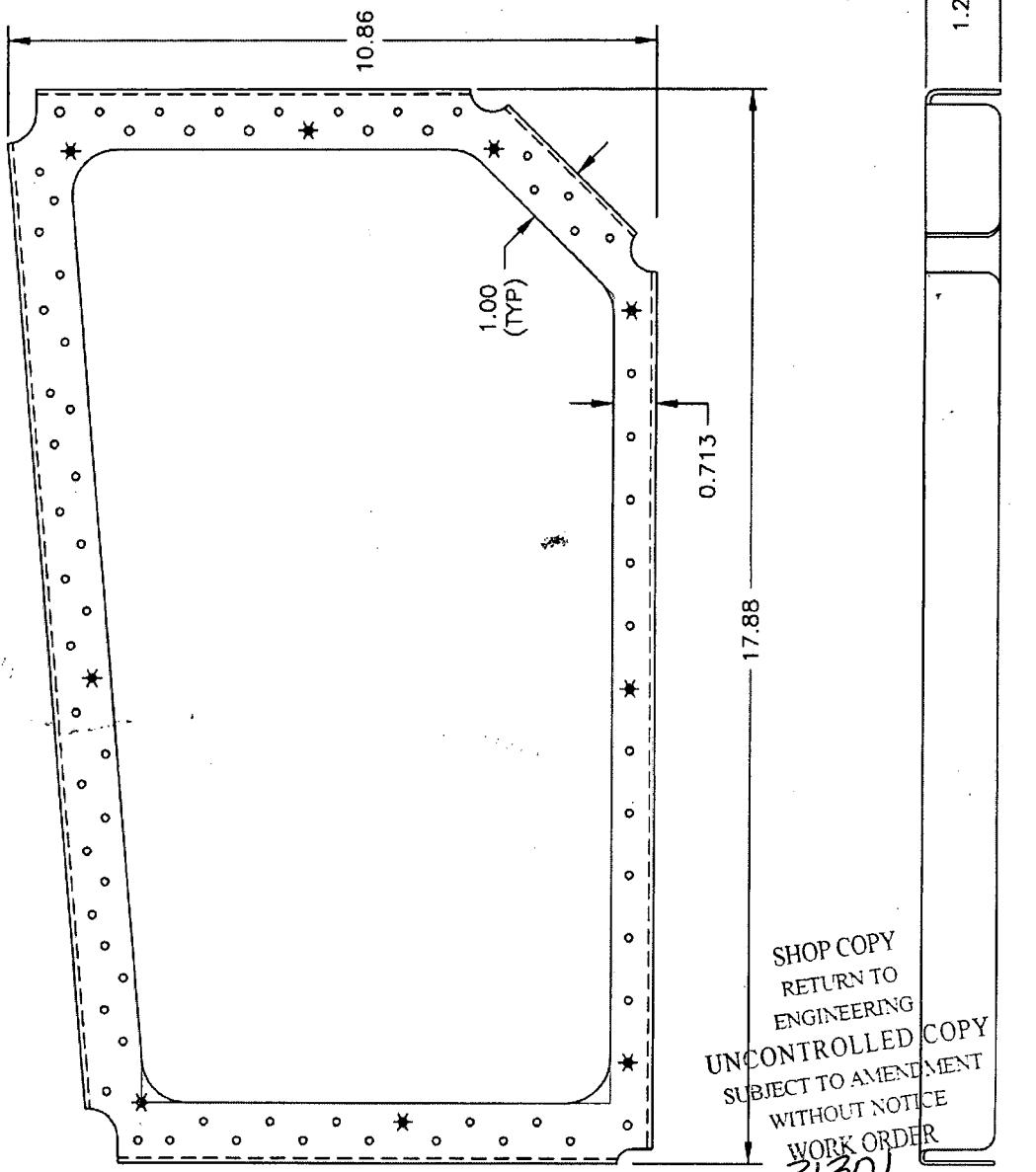
© COPY 100  
07/01

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3294	SHEET 1 OF 2
DATE		TITLE	SCALE
04.06.28		BRACKET	1:3
A	04.06.28	NEW ISSUE	
A1	05.06.13	12.97 WAS 13.03, AS MANUFACTURED	

RELEASED  
04.07.12

D3294-1 BRACKET

- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
- 2) CHECK PER TEMPLATE D3294-1T1
- 3) MATERIAL: 2024-T3 (QO-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 5) USE MINIMUM BEND RADIUS OF 0.188"
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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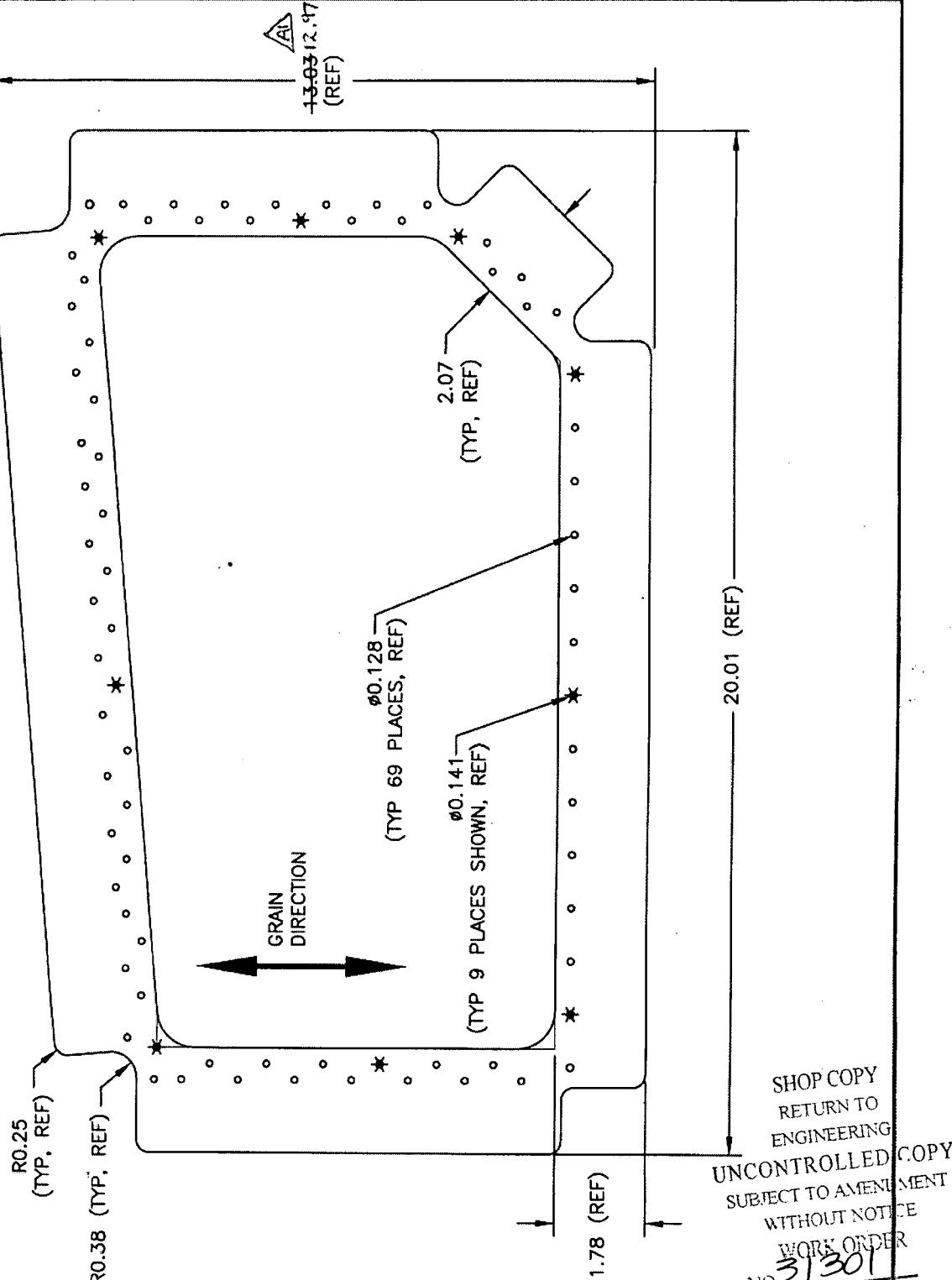
**DART**

1 COPY / 3  
CENS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3294 REV. A SHEET 2 OF 2
DATE 04.06.28		TITLE BRACKET SCALE 1:3

**D3294-1 FLAT PATTERN**

**RELEASED**  
04.07.02



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.04.02	2	One Ø0.128 HOLE					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  DQA:  Date: 07/04/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.04.02	2	One Ø0.128 HOLE DRILLED Ø0.154 on QTY(5) PARTS.	J	PARTS ACCEPTABLE. PROBLEM WAS WITH DRILL FLAT PATTERN.	N/A	AA 07/04/02	J 07.04.02	J 07/04/02
07/04/02	2	2 part scrap the Ø.128" hole are over size at Ø.135" out of tol.	J 07/04/02	-destroy	SB 07/04/02	AA 07/04/02	J 07/04/02	J 07/04/02

NOTE: Date & initial all entries